

509

DART AEROSPACE LTD	Work Order:	22143
Description: Plug	Part Number:	D2594-1
Dwg: D2594 Rev. B1	Qty:	262 250
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller	KJ	05.01.05	250
2	MC	Make as per Dwg D2594-1 and Folio FA262. Material: 5052-H32 (QQ-A-225/7) or 6061-T6 (QQ-A-225/8) 1100-0 (QQ-A-225/1) Ø0.625" Rod (M5052H32R0.625) or (M6061T6R0.625)			
3	MC	Break all sharp edges 0.010 max.	MK	05/02/03	262
4A	QC2	Inspect dimensions as per drawing D2594	MK	05/02/03	262
4B	QC8	Second check	EP	05/02/03	262
5	FP	Acid etch and alodine as per QSI 005 4.1	FF	05/05/11	262
6	FP	Powder Coat Gloss White (Ref: 4.3.5.1) per Dart QSI 005 4.3 (only larger dia. section necessary)	MK	05/06/02	262
7	QC3	Inspect Powder Coat	CD	05/06/02	262
8	FP	Identify and Stock	MK	05/06/02	262
9	AC	Cost / part 79	SJF	05-06-03	262
10	DC	Close W/O, 70 Inspect Level 21	KJ	05.06.07	262

Rev	Date	Change	Revised By	Approved
A	98.11.27	New Issue	DM	
B	00.11.01	Removed P/O for Powder Coat – in house process	EC	
C	01.07.17	Reformat step 2	SM	
D	02.08.22	Make in Cobra	KJ RF	

RELEASED
02/08/22 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____

PAR #: _____

Fault Category: _____

NCR: Yes No DQA: _____

Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____

Date: _____

DART AEROSPACE LTD	Work Order:	22143
Description: Plug	Part Number:	D2594-1
Inspection Dwg: D2594	Rev: B1	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

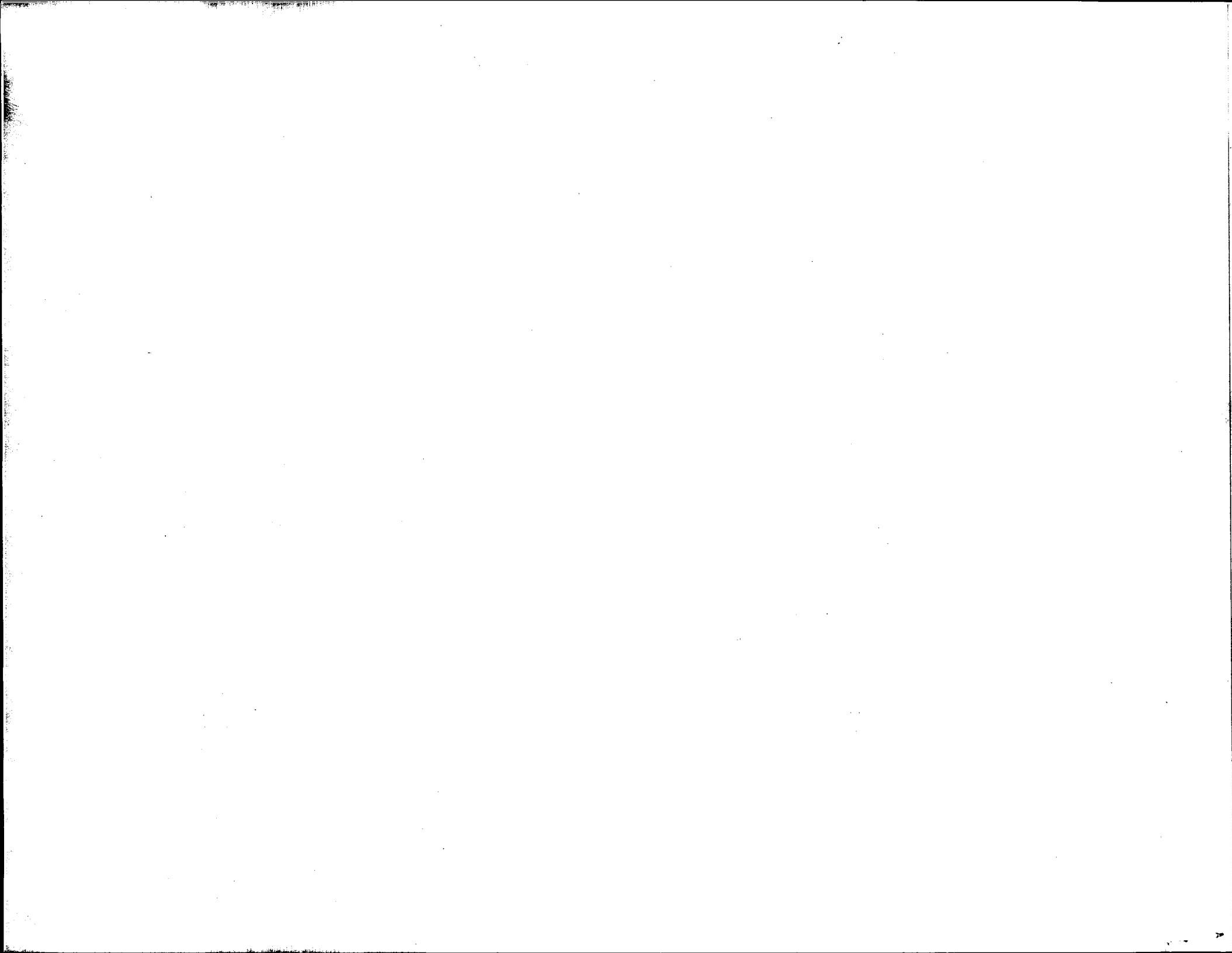
X First Article Prototype

Measured by:	<u>MK</u>	Audited by:	<u>SD</u>	Prototype Approval:	N/A
Date:	05.02.03	Date:	05.02.03	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.01.21	New Issue	KJ/RF	TS

RELEASED

04.03.24

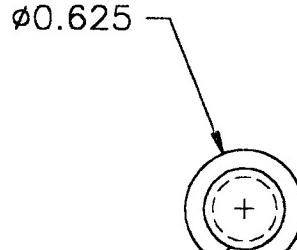
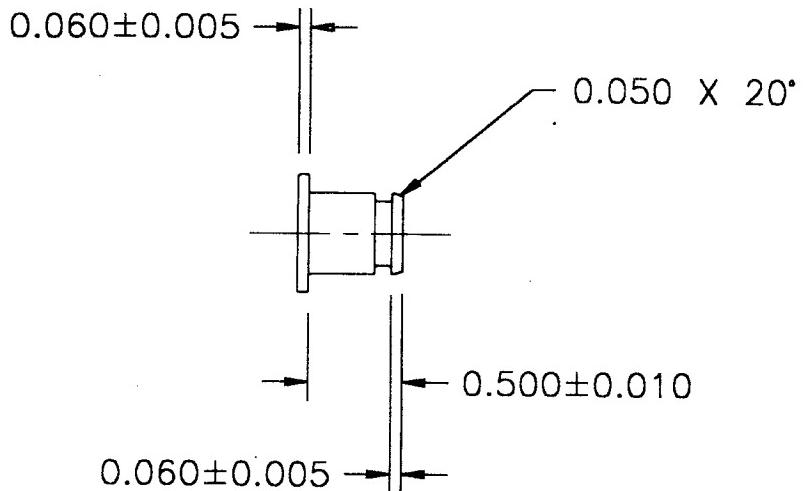




DESIGN <i>B108</i>	DRAWN BY <i>B108</i>	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>BW</i>	APPROVED <i>B108</i>	DRAWING NO. D2594
DATE 96:09:16		TITLE PLUG
		SCALE 1:1
B 97:03:15		ADD GROOVE AND O-RING
B1 RF 02.08.26		ADD Powder Coat, QSF 018 & QQ-A Specs.

D2594-1 PLUG:

RELEASED
97/03/27 DS



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RETURN TO
ENGINEERING

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 22143

(B1)

PER QQ-A-225/7 (5052)
OR QQ-A-225/8 (6061)
OR QQ-A-225/1 (1100)
OR QQ-A-200/8 (6061)

(B1)

TOLERANCES ARE PER DART QSF 018 UNLESS OTHERWISE NOTED.

BREAK ALL SHARP CORNERS 0.010 MAX

MATERIAL: 5052-H32 OR 6061-T6 OR 1100-O

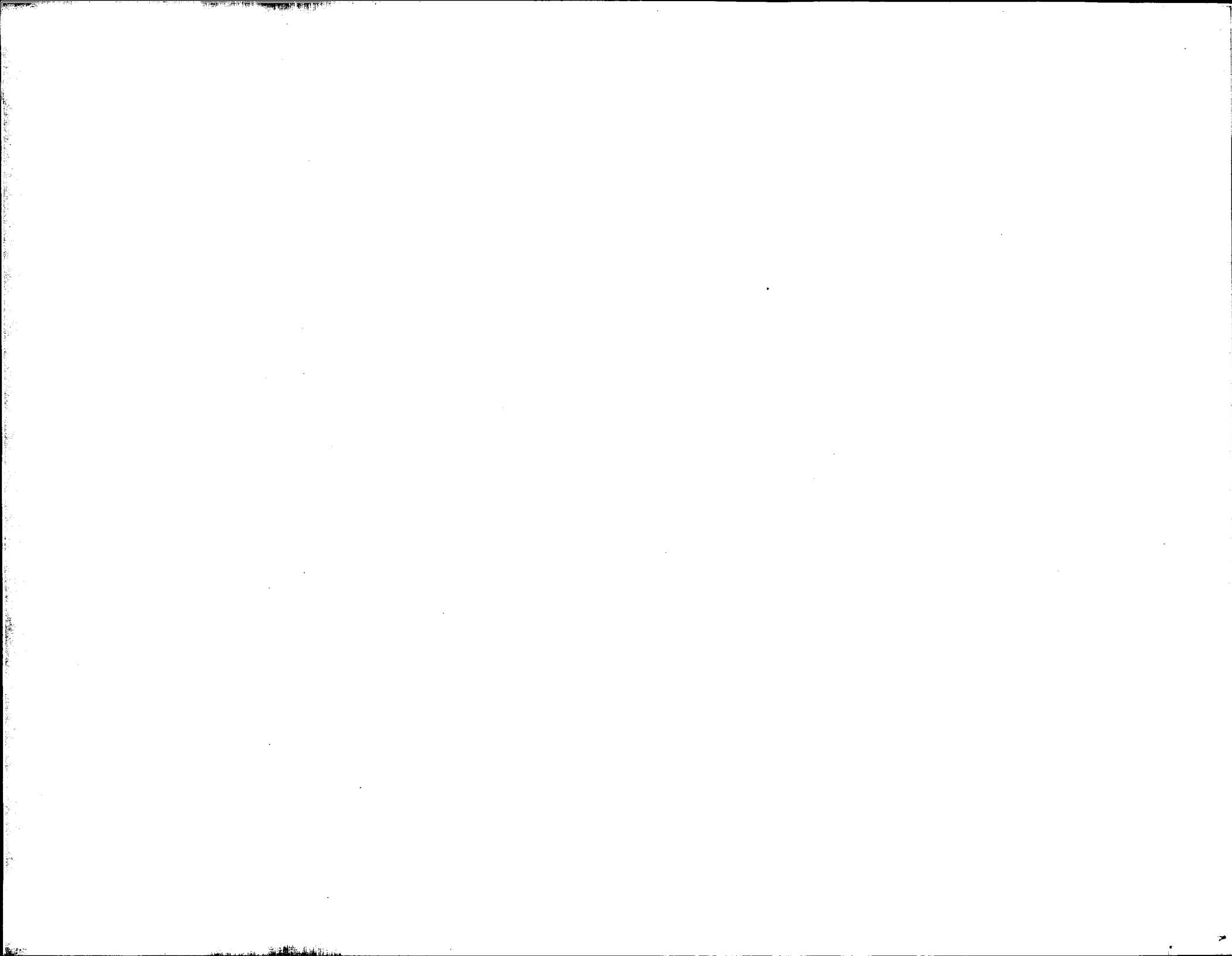
FINISH: ACID ETCH, ALODINE

Powder Coat White (Ref. 43.5.1) Per QSI 005 4.3

D2594-3 O-RING: 5/16 ID, 7/16 OD, 1/16 WIDTH
(PARKER 2-011)

D2594 PLUG ASSEMBLY INCLUDES:

- {1} D2594-1 PLUG
- {1} D2594-3 O-RING



Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 03, 2005
02:07 pm

Work Order No	:	0022143	Department Code:		
Project Name	:	D2594-1	Burden Flags	:	NNNNNNN
Project For	:	WK509	WO Status	:	Open
Work Order Type	:	Main	Invoice State	:	Not Invoiced
Main WO Number	:		Invoice Date	:	
House Part Number	:	D2594-1	Invoice Number	:	
Description	:	Plug	Invoice Amount	:	0.00
Manufactured	:	Yes			
Amount Req'd	:	250	Order Entry No	:	
Amount Done	:	0	OE Value	:	0.00
Start Date	:	01-03-05	Est Margin	:	0.000%
Est Finish Date	:	02-15-05	Actual Margin	:	0.000%
Act Finish Date	:				
Drawings Rqrd	:	No			
Ok for Approval	:				
Approval Rec'd	:		\$0 Posted to Finished Goods		

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	:	0.00	0.00	0.00	0.00
Engineering Hours	:	0.00	0.00	0.00	0.00
Engineering Cost	:	0.00	0.00	0.00	0.00
Production Hours	:	0.00	0.00	0.00	0.00
Production Cost	:	0.00	0.00	0.00	0.00
Packaging Hours	:	0.00	0.00	0.00	0.00
Packaging Cost	:	0.00	0.00	0.00	0.00
OverHead Hours	:	0.00	0.00	0.00	0.00
OverHead Cost	:	0.00	0.00	0.00	0.00
CNC Hours	:	0.00	0.00	0.00	0.00
CNC	:	0.00	0.00	0.00	0.00
Misc. Hours	:	0.00	0.00	0.00	0.00
Misc.	:	0.00	0.00	0.00	0.00
<hr/>					
Burden	:	0.00	0.00	0.00	
<hr/>					
Total Cost	:	0.00	0.00	0.00	
Margin	:	0.000	0.000		
Selling Cost	:	0.00	0.00		

	Estimated	Actual	
Labour Hrs/Amount Done	:	0.00	0.00
Profits/ (Loss)	:	0.00	0.00